

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004434**Date Inspected:** 28-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:**

Yes No

**Inspected CWI report:** Yes No N/A**Rod Oven in Use:**

Yes No N/A

**Electrode to specification:** Yes No N/A**Weld Procedures Followed:**

Yes No N/A

**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:**

Yes No N/A

**Approved Drawings:** Yes No N/A**Approved WPS:**

Yes No N/A

**Delayed / Cancelled:**

Yes No N/A

**Bridge No:** 34-0006**Component:** Tower & OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate	NA	NA	QA-MT

Tower

Heavy Shop 1: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001302. The subassembly is identified as Lift 2 tower skin plate E, welds SSD1-SA61A/G-2A, SSD1-SA61A/G-9A and SSD1-SA61A/G-17A. Caltrans QA inspector observed that the welds have been MT inspected and identified as accepted by ZPMC QC. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated, October 28, 2008 for additional information.

2	Tower Skin Plate	NA	NA	QA-UT
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Tower

Heavy Shop 2: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001301. The subassembly is identified as Lift 2, East Tower skin plate D, welds ESD1-SA376B/E-4A and ESD1-SA376B/E-1A. Caltrans QA inspector observed that the welds have been UT inspected and identified as accepted by ZPMC QC. Caltrans QA-UT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, October 28, 2008 for additional information.

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3	Deck Plate	NA	NA	QA-RT Film Review
Radiographic Film Review: ZPMC presented Report of Radiographic Examination, report number B787-RT-042 for Caltrans film review. Caltrans QA inspector reviewed radiographic film for deck panel welds DP175-001-189, DP229-001-189, DP418-001-189, DP472-001-189 and DP121-002-153. Welds and radiographic film appear to be in compliance with AWS D1.5-2002 and contract special provisions. Caltrans lot number B49-084-08 was assigned for tracking purposes.				
See Caltrans Radiographic Film Review (TL-6029), dated September 28, 2008 for additional information.				

### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishiibashi, 137-6471-0411, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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